

Date: Thursday, 7/19/2007 2:25:38 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 33660 *-12*
Estimate Number : 12712
P.O. Number :
This Issue : 7/19/2007 S.O. No. :
Prsht Rev. : NC
First Issue : 1/1 Type : SMALL / MED FAB
Previous Run : 33284
Written By :
Checked & Approved By :
Comment : Est Rev: A New Issue: 07-02-14 JLM

Drawing Name : WEARPAD
Part Number : D35371
Drawing Number : D3537 REV C
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 7/31/2007 Qty: *100* Um: Each

Additional Product

Job Number



Seq. # Machine Or Operation: Description:

10 M304S16GA 304/316 063 Sheet



Comment: Qty.: 0.0788 sf(s)/Unit Total: 6.3000 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: *M105061*

SAD 07/07/20

20 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: *C*

Prog Rev: *C*

2-Deburr if necessary

SAD 07/07/20

30 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/07/20

40 QCB SECOND CHECK



Comment: SECOND CHECK

CP 07/07/20 *(100)*

50 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

FF 07-07-30

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33660

Part Number: D35371

Job Number:



Seq. #: Machine Or Operation: Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

M105258/M105138

8/8 07/08/12

(58x)

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

8/8 07/08/12

(5)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/08/13

~~07/08/13~~

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/13

~~07/08/13~~

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

N 104846

07/08/13

07/08/13

(58x)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/08/13

(58)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-18

07/08/13

(58)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



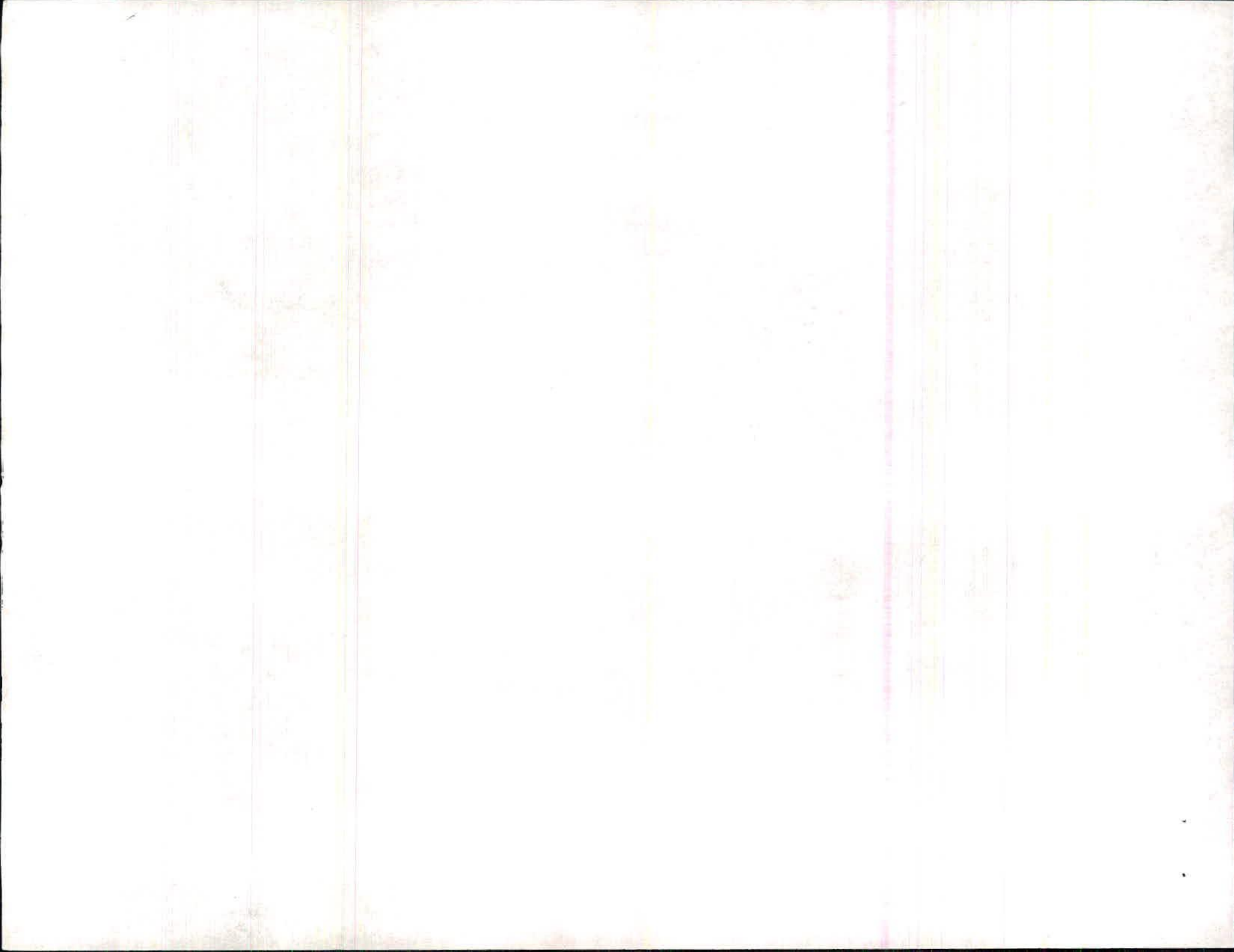
Comment: FINAL INSPECTION/W/O RELEASE

07.08.14

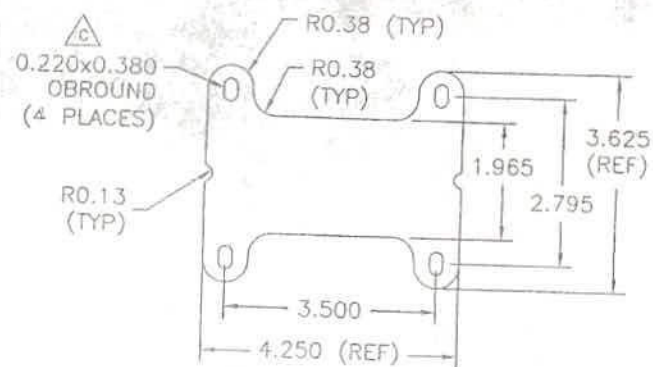
Job Completion:



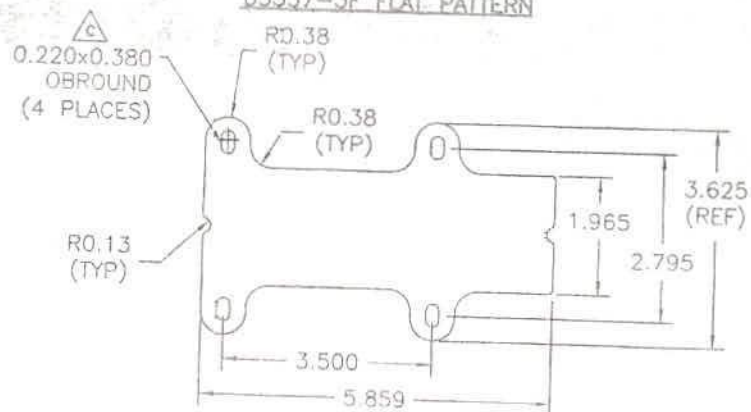
07/08/14



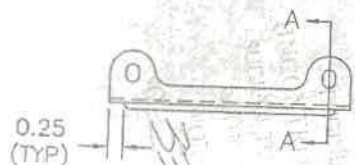
D3537-1F FLAT PATTERN



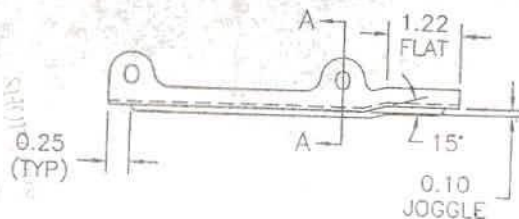
D3537-3F FLAT PATTERN



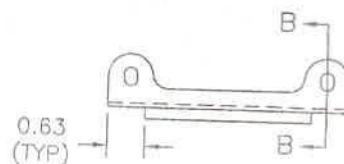
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



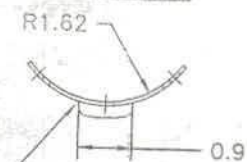
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

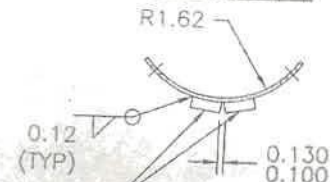


SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

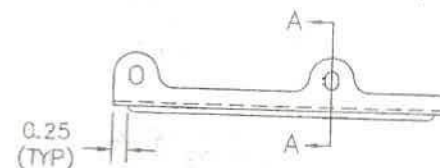
SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07.05.08 PH
per ELN
962

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX.
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD
		REV. C
		SHEET 1 OF 1
		SCALE 1:2

~~SECRET~~